

Date: Thursday, 09/11/2006 2:44:01 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE EXTRUSION
Job Number : 29413	
Estimate Number : 10047	
P.O. Number : <i>N/A</i>	Part Number : D6203
This Issue : 09/11/2006 S.O. No. : <i>N/A</i>	Drawing Number : D6203 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 16/11/2006 Qty: 60 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est. A: 01.05.16 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *2457**C206111109**60 FT*

a) Description: Angle extrusion 1.500" x 1.500" x 0.125"

b) Material: 6061-T6/T651 (QQ-A-200/8)

c) Minimum ultimate tensile strenght = 38 ksi

d) Minimum yield tensile strenght = 35 ksi

2.0

D6203P

Angle 6061T6 1.5x1.5x125



Comment: Qty.: 1.0000 f(s)/Unit Total : 60.0000 f(s)

Angle 6061T6 1.5x1.5x125

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6203

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *[Signature]*

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE EXTRUSION

Job Number: 29413

Part Number: D6203

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



65 FT.

Comment: FINAL INSPECTION/W/O RELEASE

206/11/17

Job Completion



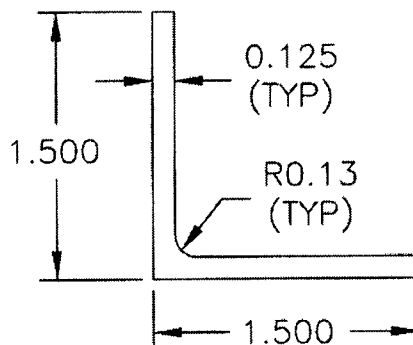
u 06/11/17



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6203	REV. A SHEET 1 OF 1
DATE 01.04.10		TITLE ANGLE EXTRUSION	SCALE 1:1
A	01.04.10	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *[Signature]*



D6203-XXX ANGLE EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6203-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM ANGLE
1.500" x 1.500" x 0.125"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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STEEL AND SPECIALTY METALS DISTRIBUTOR

N° ENR. TPS / GST REG. N° R 135 534 717 • N° ENR. TVQ / QST REG. N° 1 015 668 543

CUSTOMER ORDER NO.: N14946
CUSTOMER PART NO: V841042

09836



MILL TEST REPORT

CUSTOMER: ACIER CAMPI INC.
935, boul. du Havre
Valleyfield, Québec
J6S 5L1

SAMPLE (S) OF ALUMINUM

REPORT: 24581

DIE NO.	S-2154
DESCRIPTION	1.5"X1.5"X1/8" ANGLE
AL. ALLOY & TEMPER	6061/T6
EXTRUDEX ORDER NO.	51878-4-A.11
SPECIFICATION	ASTM B221
SILICON %	0.59
IRON %	0.24
COPPER %	0.229
MANGANESE %	0.07
MAGNESIUM %	0.89
CHROMIUM %	0.052
ZINC %	0.017
TITANIUM %	0.013
ALUMINUM %	REMAINDER
ALLOY TYPE %	6061
ALLOY CAST NO.	29450
YIELD STRENGTH (IN ksi)	41.3 ✓
TENSILE STRENGTH (IN ksi)	45.2 ✓
ELONGATION % IN 2"	13.4
HARDNESS (ROCKWELL 'F')	89.2 90.1 89.1


N. RAMPERTAB
(LAB TECH)
JAN-07-03

DATE: